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Member of



European Technical Assessment

**ETA 15/0744
of 30/10/2015**

Technical Assessment Body issuing the ETA: Technical and Test Institute
for Construction Prague

Trade name of the construction product WCF-VESF, WCF-VESF-E
galvanized or stainless steel bonded anchor

**Product family to which the construction
product belongs** Product area code: 33
Bonded injection type anchor for use
in non-cracked concrete

Manufacturer KLIMAS sp. z o.o.
Ul. Wincentego Witosa 135/137 Kuźnica
Kiedrzyńska
42-233 Mykanów, POLSKA

Manufacturing plant KLIMAS sp. z o.o.
Manufacturing plant no. 3

**This European Technical Assessment
contains** 14 pages including 10 Annexes which form
an integral part of this assessment

**This European Technical Assessment is
issued in accordance with regulation
(EU) No 305/2011, on the basis of** ETAG 001-Part 1 and Part 5, edition 2013,
used as European Assessment Document
(EAD)

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1. Technical description of the product

The WCF-VESF and WCF-VESF-E (extended curing time) with steel elements is bonded anchor (injection type).

Steel elements can be galvanized or stainless steel.

Steel element is placed into a drilled hole filled with injection mortar. The steel element is anchored via the bond between metal part, injection mortar and concrete. The anchor is intended to be used with embedment depth from 8 diameters to 12 diameters.

The illustration and the description of the product are given in Annex A.

2. Specification of the intended use in accordance with the applicable EAD

The performances given in Section 3 are only valid if the anchor is used in compliance with the specifications and conditions given in Annex B.

The provisions made in this European Technical Assessment are based on an assumed working life of the anchor of 50 years. The indications given on the working life cannot be interpreted as a guarantee given by the producer, but are to be regarded only as a means for choosing the products in relation to the expected economically reasonable working life of the works.

3. Performance of the product and references to the methods used for its assessment

3.1 Mechanical resistance and stability (BWR 1)

Essential characteristic	Performance
Characteristic resistance for tension loads	See Annex C 1
Characteristic resistance for shear loads	See Annex C 2
Displacement	See Annex C 3

3.2 Safety in case of fire (BWR 2)

Essential characteristic	Performance
Reaction to fire	Anchorage satisfy requirements for Class A1
Resistance to fire	No performance assessed

3.3 Hygiene, health and environment (BWR 3)

Regarding dangerous substances contained in this European Technical Assessment, there may be requirements applicable to the products falling within its scope (e.g. transposed European legislation and national laws, regulations and administrative provisions). In order to meet the provisions of the Regulation (EU) No 305/2011, these requirements need also to be complied with, when and where they apply.

3.4 Safety in use (BWR 4)

For basic requirement safety in use the same criteria are valid as for Basic Requirement Mechanical resistance and stability.

3.5 Sustainable use of natural resources (BWR 7)

For the sustainable use of natural resources no performance was determined for this product.

3.6 General aspects relating to fitness for use

Durability and serviceability are only ensured if the specifications of intended use according to Annex B 1 are kept.

4. Assessment and verification of constancy of performance (AVCP) system applied with reference to its legal base

According to the Decision 96/582/EC of the European Commission¹ the system of assessment verification of constancy of performance (see Annex V to Regulation (EU) No 305/2011) given in the following table apply.

Product	Intended use	Level or class	System
Metal anchors for use in concrete	For fixing and/or supporting to concrete, structural elements (which contributes to the stability of the works) or heavy units	-	1

5. Technical details necessary for the implementation of the AVCP system, as provided in the applicable EAD

5.1 Tasks of the manufacturer

The manufacturer shall exercise permanent internal control of production. All the elements, requirements and provisions adopted by the manufacturer shall be documented in a systematic manner in the form of written policies and procedures, including records of results performed. This production control system shall ensure that the product is in conformity with this European Technical Assessment.

The manufacturer may only use raw materials stated in the technical documentation of this European Technical Assessment.

The factory production control shall be in accordance with the control plan which is a part of the technical documentation of this European Technical Assessment. The control plan is laid down in the context of the factory production control system operated by the manufacturer and deposited at Technický a zkušební ústav stavební Praha, s.p.² The results of factory production control shall be recorded and evaluated in accordance with the provisions of the control plan.

The manufacturer shall, on the basis of a contract, involve a body which is notified for the tasks referred to in section 4 in the field of anchors in order to undertake the actions laid down in section 5.2. For this purpose, the control plan referred to in this section and section 5.2 shall be handed over by the manufacturer to the notified body involved.

The manufacturer shall make a declaration of performance, stating that the construction product is in conformity with the provisions of this European Technical Assessment.

¹ Official Journal of the European Communities L 254 of 08.10.1996

² The control plan is a confidential part of the documentation of the European Technical Assessment, but not published together with the ETA and only handed over to the approved body involved in the procedure of AVCP.

5.2 Tasks of the notified bodies

The notified body shall retain the essential points of its actions referred to above and state the results obtained and conclusions drawn in a written report.

The notified certification body involved by the manufacturer shall issue a certificate of constancy of performance of the product stating the conformity with the provisions of this European Technical Assessment.

In cases where the provisions of the European Technical Assessment and its control plan are no longer fulfilled the notified body shall withdraw the certificate of constancy of performance and inform Technický a zkušební ústav stavební Praha, s.p without delay.

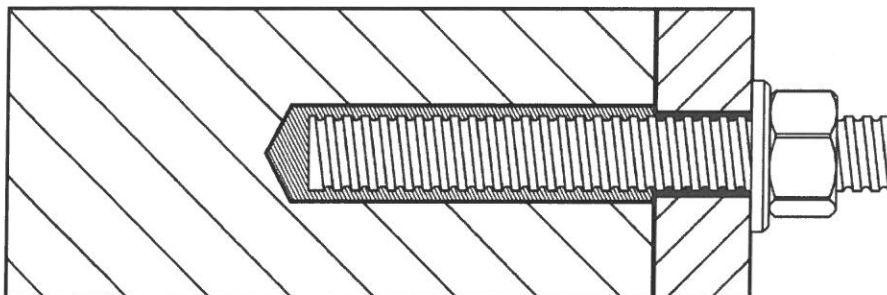
Issued in Prague on 30.10.2015



Ing. Mária Schaán
Head of the Technical Assessment Body

A handwritten signature in blue ink, likely belonging to Ing. Mária Schaán.

Threaded rod



WCF-VESF, WCF-VESF-E

Product description
Installed conditions

Annex A 1

Coaxial cartridge

WCF-VESF, WCF-VESF-E

150 ml

380 ml

400 ml

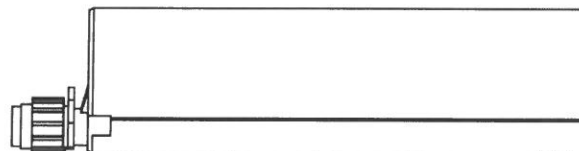
410 ml

**Side by side cartridge**

WCF-VESF, WCF-VESF-E

350 ml

825 ml

**Two part foil in a single piston component cartridge**

WCF-VESF, WCF-VESF-E

150 ml

170 ml

300 ml

550 ml

850 ml

**Peeler cartridge**

WCF-VESF, WCF-VESF-E

280 ml

**Marking of the mortar cartridges**

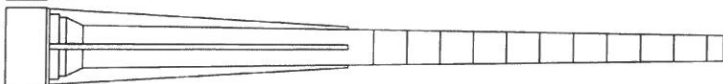
Identifying mark of the producer, Trade name, Charge code number, Storage life,
Curing and processing time

Mixing nozzle

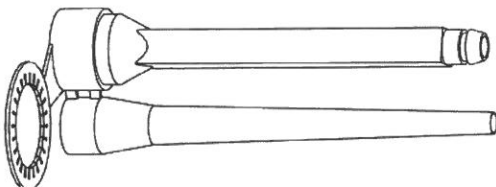
NN



WN



SN



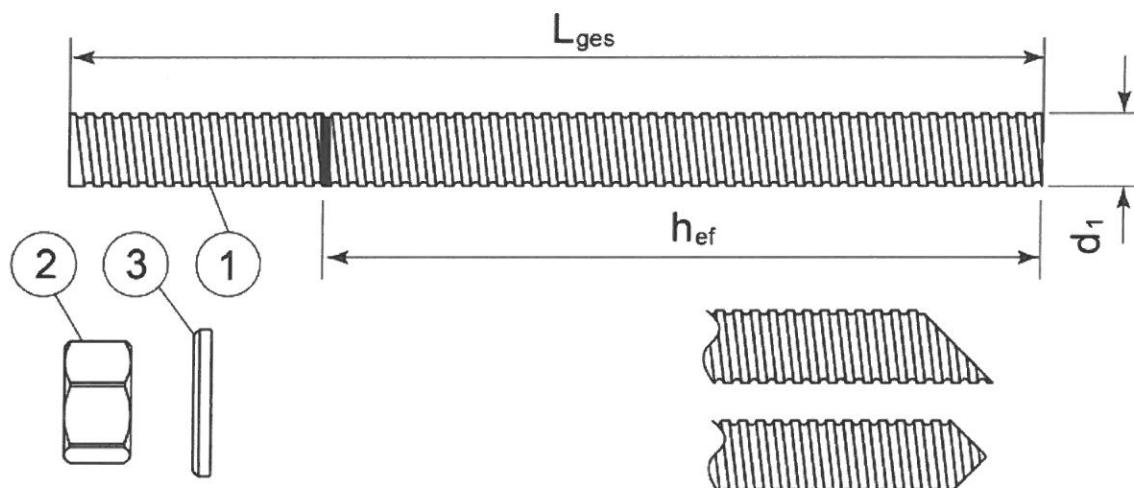
LN



KN for 850 ml

**WCF-VESF, WCF-VESF-E****Product description**
Injection system**Annex A 2**

Threaded rod M8, M10, M12, M16, M20, M24



Standard commercial threaded rod with marked embedment depth

Part	Designation	Material
Steel, zinc plated $\geq 5 \mu\text{m}$ acc. to EN ISO 4042 or Steel, Hot-dip galvanized $\geq 40 \mu\text{m}$ acc. to EN ISO 1461 and EN ISO 10684 or Steel, zinc diffusion coating $\geq 15 \mu\text{m}$ acc. to EN 13811		
1	Anchor rod	Steel, EN 10087 or EN 10263 Property class 5.8, 8.8, 10.9* EN ISO 898-1
2	Hexagon nut EN ISO 4032	According to threaded rod, EN 20898-2
3	Washer EN ISO 887, EN ISO 7089, EN ISO 7093 or EN ISO 7094	According to threaded rod
Stainless steel		
1	Anchor rod	Material: A2-70, A4-70, A4-80, EN ISO 3506
2	Hexagon nut EN ISO 4032	According to threaded rod
3	Washer EN ISO 887, EN ISO 7089, EN ISO 7093 or EN ISO 7094	According to threaded rod
High corrosion resistant steel		
1	Anchor rod	Material: 1.4529, 1.4565, EN 10088-1
2	Hexagon nut EN ISO 4032	According to threaded rod
3	Washer EN ISO 887, EN ISO 7089, EN ISO 7093 or EN ISO 7094	According to threaded rod

*Galvanized rod of high strength are sensitive to hydrogen induced brittle failure

WCF-VESF, WCF-VESF-E

Product description
Threaded rod and materials

Annex A 3

Specifications of intended use

Anchorage subject to:

- Static and quasi-static load.

Base materials

- Non-cracked concrete.
- Reinforced or unreinforced normal weight concrete of strength class C20/25 at minimum and C50/60 at maximum according EN 206-1:2000-12.

Temperature range:

- -40°C to +80°C (max. short. term temperature +80°C and max. long term temperature +50°C)

Use conditions (Environmental conditions)

- Structures subject to dry internal conditions (zinc coated steel, stainless steel, high corrosion resistance steel).
- Structures subject to external atmospheric exposure including industrial and marine environment, if no particular aggressive conditions exist (stainless steel A4, high corrosion resistance steel).
- Structures subject to permanently damp internal condition, if no particular aggressive conditions exist (stainless steel A4, high corrosion resistance steel).
- Structures subject to permanently damp internal condition, with particular aggressive conditions exist (high corrosion resistance steel).

Note: Particular aggressive conditions are e.g. permanent, alternating immersion in seawater or the splash zone of seawater, chloride atmosphere of indoor swimming pools or atmosphere with extreme chemical pollution (e.g. in desulphurization plants or road tunnels where de-icing materials are used).

Use categories:

- Category 2 – installation in dry, wet concrete or flooded hole.

Design:

- The anchorages are designed in accordance with the EOTA Technical Report TR 029 "Design of bonded anchors" under the responsibility of an engineer experienced in anchorages and concrete work.
- Verifiable calculation notes and drawings are prepared taking account of the loads to be anchored. The position of the anchor is indicated on the design drawings.

Installation:

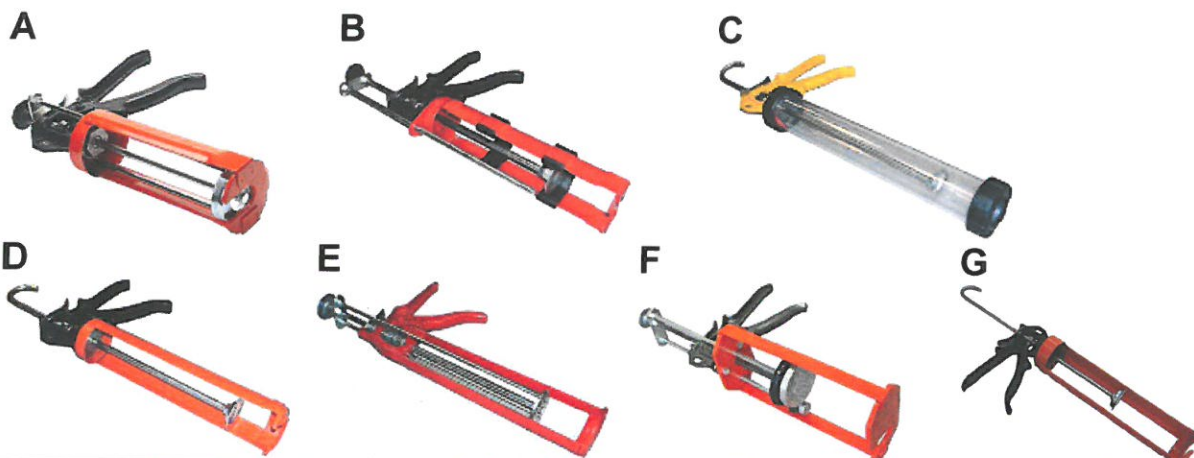
- Dry or wet concrete or flooded hole.
- Hole drilling by hammer drill mode.
- Anchor installation carried out by appropriately qualified personnel and under the supervision of the person responsible for technical matters of the site.

WCF-VESF, WCF-VESF-E

Intended use
Specifications

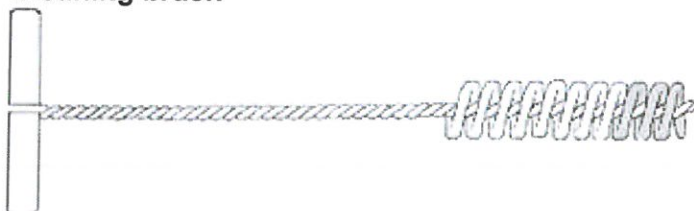
Annex B 1

Applicator gun



Applicator gun	A	B	C	D	E	F	G
Cartridge	Coaxial 380ml 400ml 410ml	Side by side 350ml	Foil capsule 170ml 300ml	Foil capsule 170ml 300ml Peeler 280ml	Coaxial 150ml	Side by side 825ml	Foil capsule 850ml

Cleaning brush



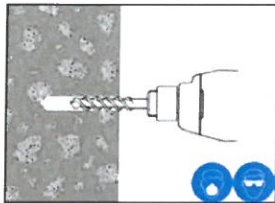
WCF-VESF, WCF-VESF-E

Intended use
Applicator guns
Cleaning brush

Annex B 2

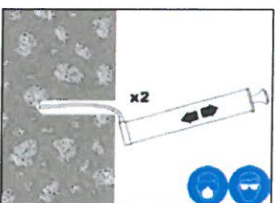
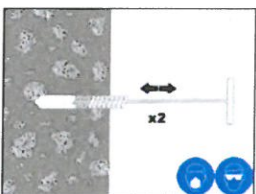
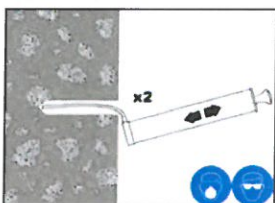
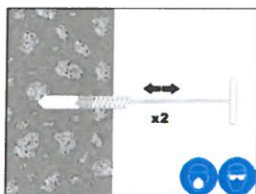
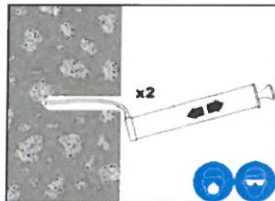
Installation procedure

1. Drill the hole to the correct diameter and depth. This can be done with either a rotary percussion or rotary hammer drilling machine depending upon the substrate.



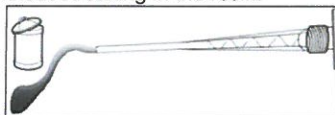
2. Thoroughly clean the hole in the following sequence using the a brush with the required extensions and a blow Pump.

Blow Clean x2.
Brush Clean x2.
Blow Clean x2.
Brush Clean x2.
Blow Clean x2.

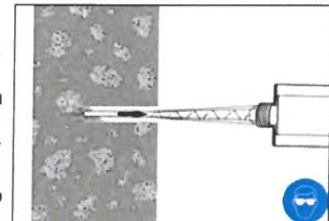


If the hole collects water after the initial cleaning this water must be removed before injecting the resin.

3. Select the appropriate static mixer nozzle for the installation, open the cartridge/foil and screw onto the mouth of the cartridge. Insert the cartridge into the correct applicator gun.
4. Extrude the first part of the cartridge to waste until an even colour has been achieved without streaking in the resin.



5. If necessary, cut the extension tube to the depth of the hole and push onto the end of the mixer nozzle, and (for threaded bar 16mm dia. or more) fit the correct resin stopper to the other end. Attach extension tubing and resin stopper.



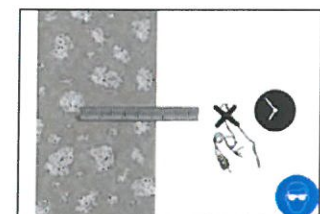
6. Insert the mixer nozzle (resin stopper / extension tube if applicable) to the bottom of the hole. Begin to extrude the resin and slowly withdraw the mixer nozzle from the hole ensuring that there are no air voids as the mixer nozzle is withdrawn. Fill the hole to approximately $\frac{1}{2}$ to $\frac{3}{4}$ full and remove the mixer nozzle completely.

7. Insert the clean threaded bar, free from oil or other release agents, to the bottom of the hole using a back and forth twisting motion ensuring all the threads are thoroughly coated. Adjust to the correct position within the stated working time.



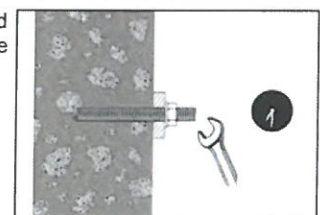
8. Any excess resin should be expelled from the hole evenly around the steel element showing that the hole is full. This excess resin should be removed from around the mouth of the hole before it sets.

9. Leave the anchor to cure. Do not disturb the anchor until the appropriate loading/curing time has elapsed depending on the substrate conditions and ambient temperature.



10. Attach the fixture and tighten the nut to the recommended torque.

Do not overtighten.



WCF-VESF, WCF-VESF-E

Intended use
 Installation procedure

Annex B 3

Table B1: Installation parameter

Size			M8	M10	M12	M16	M20	M24
Nominal drill hole diameter	Ød ₀	[mm]	10	12	14	18	22	26
Diameter of cleaning brush	d _b	[mm]	14	14	20	20	29	29
Torque moment	T _{inst}	[Nm]	10	20	40	80	150	200
h _{ef,min} = 8d								
Depth of drill hole	h ₀	[mm]	64	80	96	128	160	192
Minimum edge distance	c _{min}	[mm]	35	40	50	65	80	96
Minimum spacing	s _{min}	[mm]	35	40	50	65	80	96
Minimum thickness of member	h _{min}	[mm]	h _{ef} + 30 mm ≥ 100 mm				h _{ef} + 2d ₀	
h _{ef,max} = 12d								
Depth of drill hole	h ₀	[mm]	96	120	144	192	240	288
Minimum edge distance	c _{min}	[mm]	50	60	70	95	120	145
Minimum spacing	s _{min}	[mm]	50	60	70	95	120	145
Minimum thickness of member	h _{min}	[mm]	h _{ef} + 30 mm ≥ 100 mm				h _{ef} + 2d ₀	

Table B2: Cleaning

All diameters
- 2 x blowing
- 2 x brushing
- 2 x blowing
- 2 x brushing
- 2 x blowing

Table B3.1: Minimum curing time WCF-VESF

Resin cartridge temperature [°C]	T Work [mins]	Base material Temperature [°C]	T Load [mins]
min +5	18	min +5	145
+5 to +10	10	+5 to +10	
+10 to +20	6	+10 to +20	85
+20 to +25	5	+20 to +25	50
+25 to +30	4	+25 to +30	40
+30		+30	35

Table B3.2: Minimum curing time WCF-VESF-E

Resin cartridge temperature [°C]	T Work [mins]	Base material Temperature [°C]	T Load [mins]
min +10	30	min +10	5 hours
+10 to +20	15	+10 to +20	
+20 to +25	10	+20 to +25	145
+25 to +30	7,5	+25 to +30	85
+30 to +35	5	+30 to +35	50
+35 to +40	3,5	+35 to +40	40
+40 to +45	2,5	+40 to +45	35
+45		+45	12

T work is typical gel time at highest temperature

T load is set at the lowest temperature

WCF-VESF, WCF-VESF-E**Intended use**

Installation parameters

Curing time

Annex B 4

Table C1: Design method TR 029

Characteristic values of resistance to tension load

Steel failure – Characteristic resistance					M8	M10	M12	M16	M20	M24
Size										
Steel grade 5.8	$N_{Rk,s}$	[kN]			18	29	42	79	123	177
Partial safety factor	γ_{Ms}	[-]			1,5					
Steel grade 8.8	$N_{Rk,s}$	[kN]			29	46	67	126	196	282
Partial safety factor	γ_{Ms}	[-]			1,5					
Steel grade 10.9	$N_{Rk,s}$	[kN]			37	58	84	157	245	353
Partial safety factor	γ_{Ms}	[-]			1,4					
Stainless steel grade A2-70, A4-70	$N_{Rk,s}$	[kN]			26	41	59	110	172	247
Partial safety factor	γ_{Ms}	[-]			1,9					
Stainless steel grade A4-80	$N_{Rk,s}$	[kN]			29	46	67	126	196	282
Partial safety factor	γ_{Ms}	[-]			1,6					
Stainless steel grade 1.4529	$N_{Rk,s}$	[kN]			26	41	59	110	172	247
Partial safety factor	γ_{Ms}	[-]			1,5					
Stainless steel grade 1.4565	$N_{Rk,s}$	[kN]			26	41	59	110	172	247
Partial safety factor	γ_{Ms}	[-]			1,9					

Combined pullout and concrete cone failure in non-cracked concrete C20/25									
Size				M8	M10	M12	M16	M20	M24
Characteristic bond resistance in non-cracked concrete									
Characteristic bond resistance	τ_{Rk}	[N/mm ²]		10	8	9	9,5	8,5	8,5
Dry/wet concrete and flooded hole									
Partial safety factor	γ_{Mc}	[-]		1,8 ²⁾					
Factor for concrete	C30/37			1,12					
	C40/45	ψ_c	[-]	1,19					
	C50/60			1,30					

Splitting failure								
Size			M8	M10	M12	M16	M20	M24
Edge distance	$c_{cr,sp}$	[mm]	2,0 h_{ef}			1,5 h_{ef}		
Spacing	$s_{cr,sp}$	[mm]	4,0 h_{ef}			3,0 h_{ef}		
Partial safety factor	γ_{Msp} ¹⁾	[-]	1,8					

¹⁾ In absence of national regulations²⁾ The partial safety factor $\gamma_2=1,2$ is included

WCF-VESF, WCF-VESF-E

Performances

Characteristic resistance for tension loads

Annex C 1

Table C2: Design method TR 029
Characteristic values of resistance to shear load

Steel failure without lever arm								
Size			M8	M10	M12	M16	M20	M24
Steel grade 5.8	$V_{Rk,S}$	[kN]	9	15	21	39	61	88
Partial safety factor	γ_{Ms}	[-]	1,25					
Steel grade 8.8	$V_{Rk,S}$	[kN]	15	23	34	63	98	141
Partial safety factor	γ_{Ms}	[-]	1,25					
Steel grade 10.9	$V_{Rk,S}$	[kN]	18	29	42	79	123	177
Partial safety factor	γ_{Ms}	[-]	1,5					
Stainless steel grade A2-70, A4-70	$V_{Rk,S}$	[kN]	13	20	30	55	86	124
Partial safety factor	γ_{Ms}	[-]	1,56					
Stainless steel grade A4-80	$V_{Rk,S}$	[kN]	15	23	34	63	98	141
Partial safety factor	γ_{Ms}	[-]	1,33					
Stainless steel grade 1.4529	$V_{Rk,S}$	[kN]	13	20	30	55	86	124
Partial safety factor	γ_{Ms}	[-]	1,25					
Stainless steel grade 1.4565	$V_{Rk,S}$	[kN]	13	20	30	55	86	124
Partial safety factor	γ_{Ms}	[-]	1,56					

Steel failure with lever arm								
Size			M8	M10	M12	M16	M20	M24
Steel grade 5.8	$M^{\circ}_{Rk,s}$	[N.m]	19	37	66	166	325	561
Partial safety factor	γ_{Ms}	[-]	1,25					
Steel grade 8.8	$M^{\circ}_{Rk,s}$	[N.m]	30	60	105	266	519	898
Partial safety factor	γ_{Ms}	[-]	1,25					
Steel grade 10.9	$M^{\circ}_{Rk,s}$	[N.m]	37	75	131	333	649	1123
Partial safety factor	γ_{Ms}	[-]	1,50					
Stainless steel grade A2-70, A4-70	$M^{\circ}_{Rk,s}$	[N.m]	26	52	92	233	454	786
Partial safety factor	γ_{Ms}	[-]	1,56					
Stainless steel grade A4-80	$M^{\circ}_{Rk,s}$	[N.m]	30	60	105	266	519	898
Partial safety factor	γ_{Ms}	[-]	1,33					
Stainless steel grade 1.4529	$M^{\circ}_{Rk,s}$	[N.m]	26	52	92	233	454	786
Partial safety factor	γ_{Ms}	[-]	1,25					
Stainless steel grade 1.4565	$M^{\circ}_{Rk,s}$	[N.m]	26	52	92	233	454	786
Partial safety factor	γ_{Ms}	[-]	1,56					
Concrete pryout failure								
Factor <i>k</i> from TR 029			2					
Design of bonded anchors, Part 5.2.3.3								
Partial safety factor	γ_{Mp}	[-]	1,5					

Concrete edge failure						
Size	M8	M10	M12	M16	M20	M24
See section 5.2.3.4 of Technical Report TR 029 for the Design of Bonded Anchors						
Partial safety factor	γ_{Mc} ¹⁾	[-]	1,5			

¹⁾ In absence of national regulations

WCF-VESF, WCF-VESF-E

Performances

Characteristic resistance for shear loads

Annex C 2

Table C3: Displacement under tension and shear load

Anchor size			M8	M10	M12	M16	M20	M24
Tension load	F	[kN]	6,3	7,9	11,9	23,8	29,8	45,6
Displacement	δ_{N0}	[mm]	0,2	0,2	0,3	0,5	0,7	0,9
	$\delta_{N\infty}$	[mm]	0,4	0,4	0,4	0,4	0,4	0,4
Shear load	F	[kN]	5,2	8,3	12,0	22,4	35,0	50,4
Displacement	δ_{V0}	[mm]	0,1	0,1	0,2	0,4	0,8	1,5
	$\delta_{V\infty}$	[mm]	0,2	0,2	0,3	0,6	1,2	2,3

WCF-VESF, WCF-VESF-E

Performances
Displacement

Annex C 3



TECHNICKÝ A ZKUŠEBNÍ ÚSTAV STAVEBNÍ PRAHA, s.p.
Technical and Test Institute for Construction Prague

Akreditovaná zkušební laboratoř, Autorizovaná osoba, Notifikovaná osoba, Oznamovaný subjekt, Subjekt pro technické posuzování, Certifikační orgán, Inspekční orgán / Accredited Testing Laboratory, Authorized Body, Notified Body, Technical Assessment Body, Certification Body, Inspection Body. Prosecká 811/76a, 190 00 Praha 9 - Prosek, Czech Republic

CERTIFICATE OF CONSTANCY OF PERFORMANCE

No. 1020 – CPR – 090-034842

In compliance with Regulation 305/2011/EU of the European Parliament and of the Council of 9 March 2011 (the Construction Products Regulation or CPR), this certificate applies to the construction product:

WCF-VESF, WCF-VESF-E

Bonded injection type anchor for use in non-cracked concrete

produced by or for

KLIMAS sp. z o.o.

Ul. Wincentego Witosa 135/137 Kuźnica, Kiedrzyńska, 42-233 Mykanów, POLSKA

and produced in the manufacturing plant

KLIMAS sp. z o.o.

Manufacturing plant no. 3

This certificate attests that all provisions concerning the assessment and verification of constancy of performance described in the ETA

ETA 15/0744

under system 1 for the performances set out in this certificate are applied and that

the construction product fulfils all the prescribed requirements for these performances.

This certificate was first issued on 20th November 2015 and remains valid as long as the ETA remains valid and the manufacturing conditions in the plant or the factory production control itself are not modified significantly, unless suspended or withdrawn by the product certification body.

The stamp of the Notified Body 1020

Prague, 20th November 2015



Ing. Jozef Pôbiš
Manager of the Notified Body